

# Work Order ID 115766

May-23-14 10:10:36 AM

**\*115766\***

Page 1

Item ID: D2671 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw, 206 Narrow  
 Start Date: 4/04/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 4/04/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2671                          | Rev B1                   |                      |         |        |              |               |               |                  |                |

105 0.00  
**\*105\***  
 Purchasing Memo 0.00  
 Purchasing ISSUE PO 24350  
 Cut Blank as per File D2671\_BLANK

CL 4/105/26 4

115 0.00  
**\*115\***  
 Packaging Memo 0.00  
 Packaging

HX SP/4-6-10

125 0.00  
**\*125\***  
 QC Memo 0.00  
 Quality Control

4 8 14/06/17

May-23-14 10:10:36 AM

**\*1 15766\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Bearpaw, 206 Narrow

**Start Date:** 4/04/14      **Start Qty:** 4.00      **\*4\***

**Cust Item ID:**

**Required Date:** 4/04/14      **Req'd Qty:** 4.00      **\*/\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

**\*130\***

## HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

## Memo

## HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671  
3-Deburr

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

## Memo

0.00

QC

## Quality Control

150

QC8- Inspect parts - second check

0.00

**\*150\***

## Memo

0.00

OC

## Quality Control

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Page 3

44-6-18

# Picklist Print

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Page 1

Work Order ID: 115766

\*115766\*

Parent Item: D2671

\*D2671\*

Parent Item Name: Bearpaw, 206 Narrow

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 4.00

Required Qty: 4.00

## Comments:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10                        |                        | Purchased     | No          |                     |                  | 120             | sf                 | 400.0000       | 2.7         | 11           |               |                |        |

\*MUHMWB10\*

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

\*\*

CL 14/05/28

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT018          | 400            |                 |
| m128267         | 47             |                 |
| m128668         | 353            |                 |

m129293

|                              |                |                     |        |
|------------------------------|----------------|---------------------|--------|
| <b>DART AEROSPACE LTD</b>    |                | <b>Work Order:</b>  | 115766 |
| <b>Description:</b> Bearpaw  |                | <b>Part Number:</b> | D2671  |
| <b>Inspection Dwg:</b> D2671 | <b>Rev:</b> B1 | <b>Page 1 of 1</b>  |        |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet<br>Drawing Dimension |             | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|-------------|---------------|---------------------|--------|--------|-------------------------|----------|
| A                                     | 0.063 x 45° | +0.030/-0.010 | 0.05 x 45°          | ✓      |        | MH-04                   | Caliper  |
| B                                     | 5.500       | +/-0.030      | 5.495               | ✓      |        |                         |          |
| C                                     | 0.200       | +/-0.030      | .195                | ✓      |        |                         |          |
| D                                     | R0.250      | +/-0.030      | .250                | ✓      |        | rad stage               | -        |
| E                                     | 0.625       | +/-0.030      | .635                | ✓      |        | MH-04                   | Caliper  |
| F                                     | 0.250       | +/-0.010      | .260                | ✓      |        |                         |          |
| G                                     | 0.950       | +0.030/-0.010 | .972                | ✓      |        |                         |          |
| H                                     | 0.25 x 45°  | +/-0.030      | .25 x 45            | ✓      |        |                         |          |
| I                                     | 0.375       | +/-0.010      | .385                | ✓      |        |                         |          |
| J                                     | 12.750      | +/-0.030      | 12.750              | ✓      |        | MH-07                   | tape     |
| K                                     | Ø0.260      | +0.005/-0.000 | .260                | ✓      |        | MH-04                   | caliper  |
| L                                     | Ø0.93       | +/-0.030      | .925                | ✓      |        |                         |          |
| M                                     | 0.30        | +0.030/-0.000 | .310                | ✓      |        |                         |          |
| N                                     | 4.250       | +/-0.030      | 4.25                | ✓      |        |                         |          |
| O                                     | 0.375       | +/-0.030      | .375                | ✓      |        |                         |          |
| P                                     | 2.000       | +/-0.030      | 2.00                | ✓      |        |                         |          |
| Q                                     | 4.250       | +/-0.010      | 4.25                | ✓      |        |                         |          |
| R                                     | 9.000       | +/-0.010      | 9.00                | ✓      |        | Tape                    | MH-07    |
| S                                     | 15.750      | +/-0.030      | 15.75               | ✓      |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |
|                                       |             |               |                     |        |        |                         |          |

|                           |                                |                            |     |
|---------------------------|--------------------------------|----------------------------|-----|
| <b>Measured by:</b> MH-04 | <b>Audited by:</b> [Signature] | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 14/06/17     | <b>Date:</b> 14/6/17           | <b>Date:</b>               |     |

| Rev | Date     | Change    | Revised by        | Approved    |
|-----|----------|-----------|-------------------|-------------|
| A   | 03.09.22 | New Issue | KJ/RF [Signature] | [Signature] |

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B1 02.12.17 |  $\phi 0.93$  WAS  $\phi 0.75$  ~~14~~

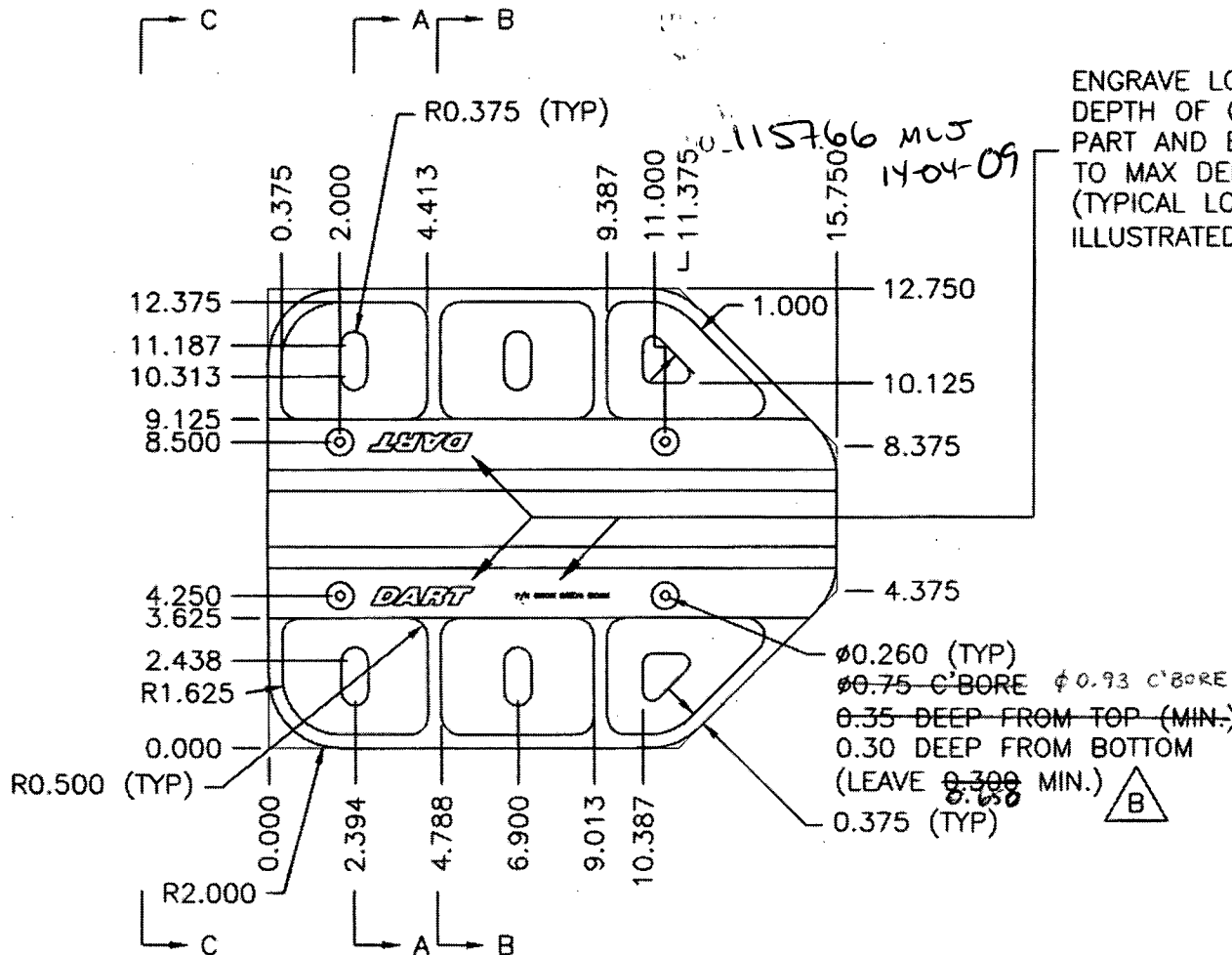


| DESIGN   | DRAWN BY | DART AEROSPACE LTD             |
|----------|----------|--------------------------------|
| KE       | KE       | HAMKESBURY, ONTARIO, CANADA    |
| CHECKED  | APPROVED | DRAWING NO.                    |
| WJ       | AS       | D2671                          |
| DATE     | TITLE    | SCALE                          |
| 98.05.19 | BEARPAW  | 1:5                            |
| A        | 97.04.08 | NEW ISSUE                      |
| B        | 98.05.19 | CHANGE C'BORE, R1.58 WAS R1.50 |

**RELEASED**  
99.06.17 KE

EFFECTIVE DEOS  
9143

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

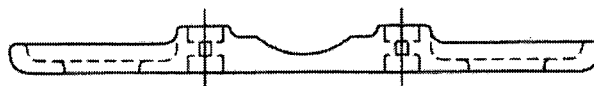
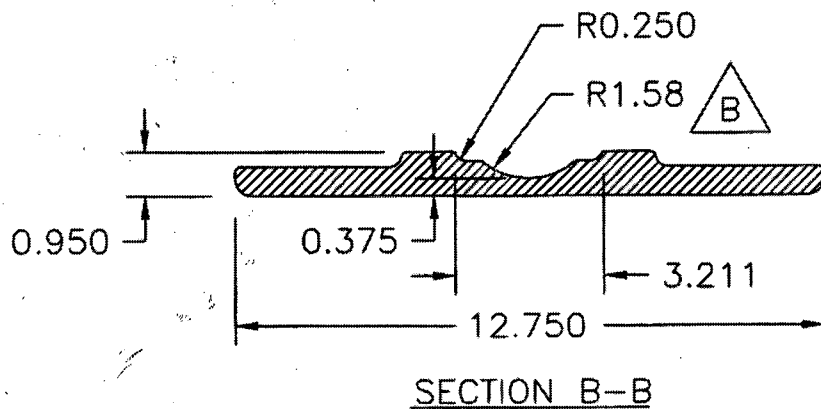
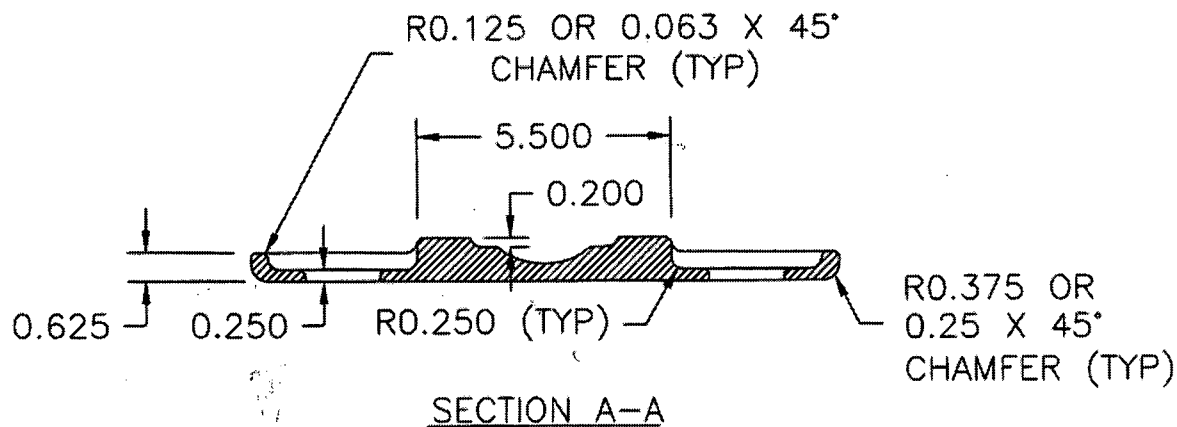


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>KE     | DRAWN BY<br>KE          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>BIB   | APPROVED<br>[Signature] | DRAWING NO.<br>D2671                              | REV. B<br>SHEET 2 OF 2 |
| DATE<br>98.05.19 |                         | TITLE<br>BEARPAW                                  | SCALE<br>1:4           |

RELEASED  
98.06.17 KE







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO24350

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 2 of 4

**Order From :**

VC-TPI001

**Ship To :** DART AEROSPACE LTD

TPI INDUSTRIES INC.  
148 RUE GOODFELLOW  
DELSON, QUEBEC J5B 1V4  
CANADA

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone**

450-633-0484

**Ship To Contact**

**Ship To Phone**

**Ship Via:**

Day & Ross collect

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Line Total:** \$349.

4 117436

D2521 BEARPAW

6/13/2014

12.00 ✓

\$55.36

\$664.

Yes

6/13/2014

CUT BLANK AS PER FILE

**Line Total:** \$664.

5 115766

D2671 BEARPAW

6/13/2014

4.00 ✓

\$24.42

\$97.

Yes

6/13/2014

CUT BLANK AS PER FILE

**Line Total:** \$97.

6 117867

D2916-1 CABLE GUARD

6/13/2014

8.00 ✓

\$21.70

\$173.

Yes

6/13/2014

CUT BLANK AS PER FILE

**Line Total:** \$173.

**Note:**

5/26/2014